



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A93-3400-00

Job Sheet 179018



Part No: RBE350A93-3400-00

Job Qty: 1 ea

Part Name: Drive Shaft Thimble



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 6/12/18

Job Tracking No:

Due Date: 7/3/18

Created By: Logan David

Type: SOLD

Description:

Note: RBE350A93-3400-00 REV 3 IPP REV A 18-01-16 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		7/3/18	0.00	0.00	Start Up Small Fab-4		MCC
100	Small Fab	1 pcs		7/3/18	0.08	0.10	Small Fab-9		MCC DAS 38
110	QC	1 pcs		7/3/18	0.00	0.00	QC5		38
130	Packaging	1 pcs		7/3/18	0.00	0.00	Packaging3-2		SP18-7-12 9-88
140	QC21-FG	1 Ea		7/3/18	0.00	0.00	QC21		DAS 21 9-88

Part Op 100 - Assemble as per DWG
Descriptions: 130 - Identify and Stock

JUL 12 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
4491K61	Push in tapered round cap	1 Ea (1 ea)	90-Start up Operation	3038435
RBE350A93-3400-00-1	Guide	1 Ea (1 ea)	90-Start up Operation	3052474

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	4491K61	1	94	0
	RBE350A93-3400-00-1	1	13	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

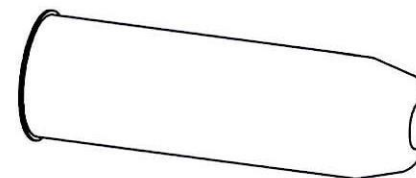
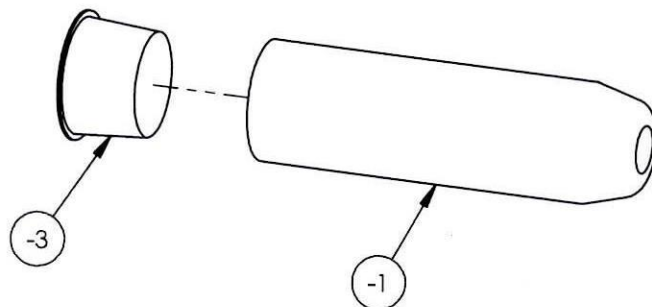
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																					
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Date : _____		Step #: _____		Effective : _____		MRB (QSI042) Approval																																																					
Description Work Order DART Aerospace Container No: S090950 Part: FBE350A93 Job No: 179018 Serial No/Batch: 3400-00 Revision: 3 Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/11/18						Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																					
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		DESIGNED FROM HELI PRODUCTS TOOLS.	10/15/2009	WP	DW
2		CH'D THIMBLE TO GUIDE AND MATERIAL FROM 4140 Q&T. ADDED BLEND NOTE PER D.W.	9/15/2011	RJC	DW
2A		CH'D T/N WAS RBEA93-3400-00 IS RBE350A93-3400-00.	11/6/2013	RJC	RW
3	17-0172	UPDATED TO NEW STANDARD. ADDED DASH NUMBERS. -1 CH'D ENGRAVE NOTE WAS ENGRAVE T/N, S/N, & "MADE IN USA" TO FIT IS ENGRAVE T/N. ADDED FINISH SPEC QMSH-6.2.2, B.O. REV D. CH'D MAT'L FROM 4140 TO 4140/4142. DELETED DIMS (.630), 75°. ADDED DIMS 3.718±.050, 15°. CH'D DIM WAS R.200 IS R.20.	7/13/2017	DPD	JAG



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WITHOUT NOTICE
WORK ORDER
NO. 179018 MJD
180706

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	GUIDE	4140/4142		2
		B/O	-3	1	PUSH IN TAPERED ROUND CAP	PLASTIC	Ø1.298 I.D. X Ø1.173 I.D. X 13/16 (MCMaster-CARR #4491K61)	1

DART AEROSPACE	
TITLE DRIVESHAFT THIMBLE	
DWG NO. RBE350A93-3400-00	REV 3
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 07/13/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/21/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/24/2017	USED ON MODEL
APPROVED: JAG 07/26/2017	EUROCOPTER 350/355
SCALE 1:2	DATE 10/15/2009
SHEET 1 OF 2	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

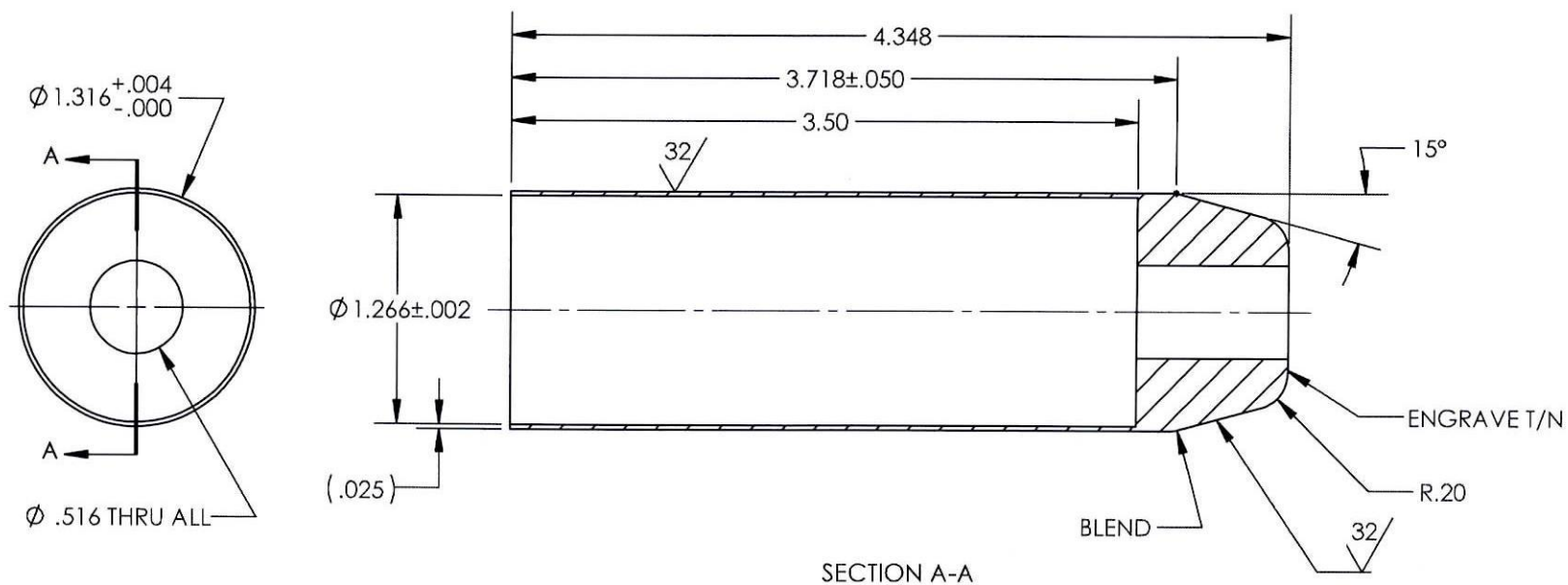
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

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SECTION A-A

(-1)
GUIDE

DART AEROSPACE	
TITLE DRIVESHAFT THIMBLE	
DWG NO. RBE350A93-3400-00-1	REV 3
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± .5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES 015 x 45° OR .015R
CHECKED: RJC 07/13/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/21/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/24/2017	USED ON MODEL
APPROVED: JAG 07/26/2017	EUROCOPTER 350/355
SCALE 1:1	DATE 10/15/2009
SHEET 2 OF 2	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
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